

X

Work Order ID 71682

Thursday, July 07, 2011 12:13:17 PM



Item ID:	D3259-5	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Spacer					
Start Date:	7/7/2011	Start Qty:	12.00		Cust Item ID:	
Required Date:	7/21/2011	Req'd Qty:	12.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>CY</u>	Date:	<u>11/07/07</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3259	Rev B								

100	FLOW WATER JET	0.00							
	Waterjet	Memo	0.00						
FLOW CNC Waterjet	I-Cut as per Dwg D3259	<input type="checkbox"/> Dwg Rev: <u>B</u>	<input type="checkbox"/> Prog Rev: <u>B</u>	<input type="checkbox"/> 2-					
<u>2024.032</u>	Debur if necessary								

B11-8-15

(12)

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC	Memo	0.00						
Quality Control									

B11-8-15

120	QC8- Inspect parts - second check	0.00							
	QC	Memo	0.00						
Quality Control									

S vlos 1/16

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run Start	
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							
140 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							
150 Packaging Packaging	Identify as per dwg & Stock Location: <u>180A</u> Memo	0.00 0.00							

12 d M 108/16

12 X d M 11/08/16

11/8/17 1205

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Item ID: D3259-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Spacer

Start Date: 7/7/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

211-08-18
12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 71682

Parent Item: D3259-5

Parent Item Name: Spacer





Start Date: 7/7/2011

Required Date: 7/21/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-07-19 JLM Verified By:EC IPP REV
B:AS PER REV B 10-05-19 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.032		Purchased	No			100	sf	24.4000	1.388	17.53263		10.6	
												11-8-15	

2024-T3 .032 sheet

Location

Loc Qty

Loc Code

MAT22

24.4

111699

0.5

113189

23.9

113189

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

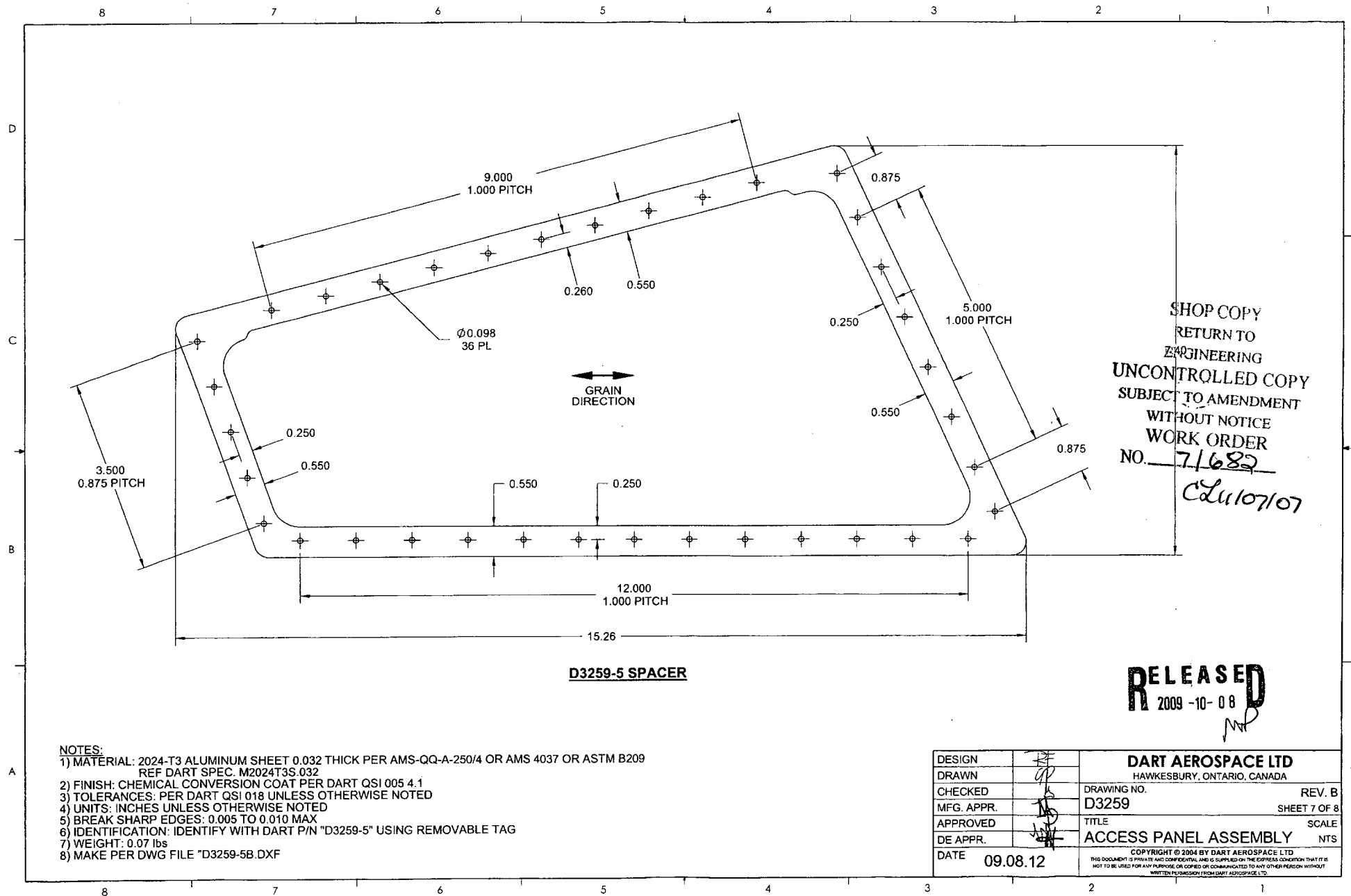
DART AEROSPACE LTD		Work Order:	71682
Description: Spacer		Part Number:	D3259-5
Inspection Dwg: D3259 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
9.000	+/-0.005	8.999	2		PROW 32	
1.000	+/-0.005	.999	2		U B 62	
5.000	+/-0.005	4.996	2		U	
12.000	+/-0.005	12.000	2		P	
3.5000	+/-0.005	3.499	2		U	
0.875	+/-0.005	.877	2		V	
0.260	+/-0.010	.260	2		V	
R0.50	+/-0.030	.50	2		R.G	
0.250	+/-0.010	.250	2		V	
0.875	+/-0.005	.876	2		V	
Ø0.098	+0.005/-0.000	.101	X		V	
0.550	+/-0.010	.558	2		V	
R0.50	+/-0.030	.50	2		R.G	
10.062	+/-0.010	?				
R0.13	+/-0.030	.13	2		R.G	
0.032 thick	+/-0.010	.033	2		V	
0.130	+/-0.010	.130	2		V	

Measured by: RB	Audited by: S	Preliminary Approval:
Date: 11-8-15	Date: 11/08/16	Date:

Rev	Date	Change	Revised by	Approved
A	04.08.25	New Issue P/O D412-705-019	KJ/JLM	
B	10.06.07	Dwg Rev updated	KJ	M



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 71682
CL1107/07